

Slp 18/11
~~*76577*~~

Work Order ID 76577

November-17-11 1:48:45 PM

Page 1

Item ID: D3234-1

Accept

~~*N9000401000*~~ PRELIMINARY ISSUE *NS1*

Revision ID: U/R

Item Name: Doubler

Stop *NS2*

Start Date: 17/11/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 17/11/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: M.C.J

Date: 11/11/17

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3234

PC3

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3234 Dwg Rev PC3 Prog Rev 2-
Deburr if necessary

181117

(S)

SCRAP

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

181117

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

inspected to PC1
Dwg only
Dwg 11/17

(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76577

76577

Page 2

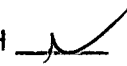
November-17-11 1:48:45 PM

Item ID: D3234-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Doubler
 Start Date: 17/11/2011 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 17/11/2011 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							5x φ M - 11/11/17
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							5 BR 11-11-17.
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							Phs →

POSITIVE RECALL

EFFECTIVE 11/11/17 AUTH 

RELEASED _____ DATE _____

MF
11-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3234-1 PAR #: _____ Fault Category: Eng NCR: Yes No DQA: Auto Date: 11/11/29
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/11/30

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/29	#150	Design change RC: CONFIGURATION CONTROL	S 11/11/21	Scrap all parts	S 11/11/21	S 11/11/21	S 11/11/21	S 11/11/21
			052042				052042	

NOTE: Date & initial all entries

Work Order ID 76577***76577***

Page 3

November-17-11 1:48:45 PM

Item ID: D3234-1

Accept

N900040100Setup Start ***NS1***

Revision ID: U/R

Stop ***NS2***

Item Name: Doubler

Start Date: 17/11/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 17/11/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-17-11 3:08:53 PM

Page 1

Work Order ID: 76577

76577

Parent Item: D3234-1

D3234-1

Parent Item Name: Doubler

Start Date: 17/11/2011

Required Date: 17/11/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 08-08-14 JLM Verified By:EC
IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

77.1000

0.579

3.047368

M2024T3S 050

11-11-17

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT022

77.1

117684

77.1

117684

5

DART AEROSPACE LTD	Work Order: 76577
Description: Doublet	Part Number: D3034-1
Inspection Dwg: D3034-1, Rev: PC3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

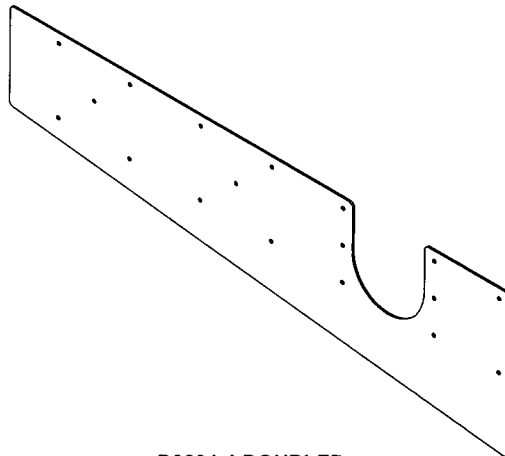
☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.098	+0.004 -0.001	1.100	✓		V	B02
1.523	±.010	1.522	2		V	
2.641	±.010	2.642	2		V	
3.758	±.010	3.761	2		V	
5.993	±.010	5.991	2		V	
7.111	±.010	7.113	2		V	
8.228	±.010	8.232	2		PROV302	
10.463	±.010	10.466	2		P	
10.777	±.030	10.787	2		P	
2.225	±.030	2.245	2		V	
13.333	±.010	13.333	1		T	B01
15.366	±.010	15.366	1		T	
15.665	±.010	15.665	1		T	
1.33	±.030	1.33	2		V	
4.505	±.010	4.505	2		V	
.285	±.010	.286	2		V	
1.295	±.010	1.291	2		V	
2.305	±.010	2.301	2		V	
2.700	±.010	2.700	2		V	
.050	±.010	.049	2		V	

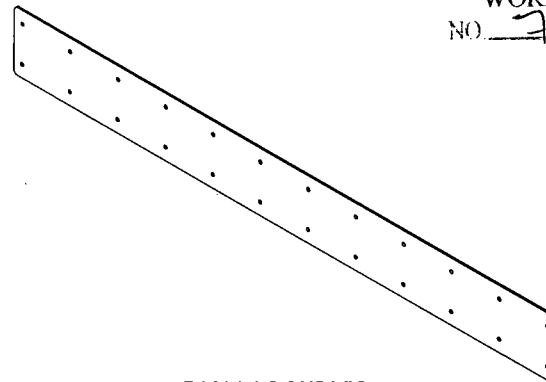
Measured by: ID	Audited by: S	Prototype Approval:
Date: 11-11-17	Date: 11/11/17	Date:
10 PCI Day only		
Rev A	Date -	Change New Issue
Revised by KJ/JLM		Approved

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

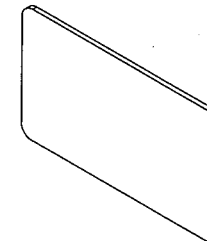
NO. 76577 M.L.J
 11/11/17



D3234-1 DOUBLER



D3234-3 DOUBLER



D3234-5 SPACER

NOTES:

1) MATERIAL: -1 & -3: 2024-T3 ALUMINUM SHEET, 0.050 THICK
 PER AMS-QQ-A-250/4 OR AMS 4037
 REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK
 PER AMS-QQ-A-250/8 OR AMS 4016
 REF DART SPEC M5052H32S.050

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 7) WEIGHT: -1: 0.26 lbs
 -3: 0.15 lbs
 -5: 0.01 lbs

PRELIMINARY ISSUE

SC 11.09.29

PC3	RE-DESIGNED D3234-1 TO FIT D3025-1 REV. B. ZONE C3-2, 4.505 WAS 5.347. ZONE D8-2, 2.700 WAS 2.841. REASON: REF PAR 11-118.	<i>SC</i>	11.09.29
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>SC</i>	DRAWING NO.	REV. PC3
CHECKED	<i>SC</i>	D3234	SHEET 1 OF 2
MFG. APPR.	<i>SC</i>	TITLE	SCALE
APPROVED		DOUBLER	NTS
DE APPR.		COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	11.09.29		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

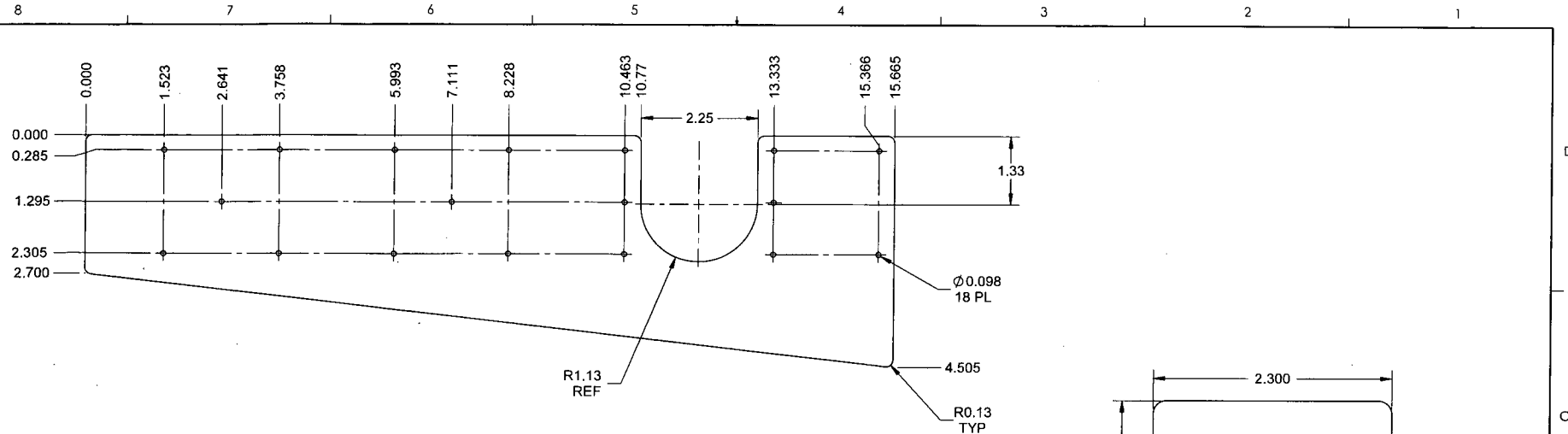
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

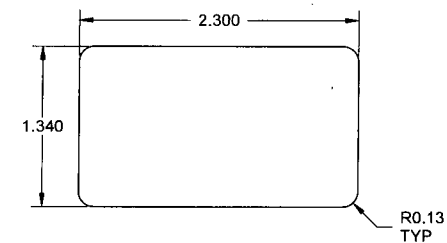
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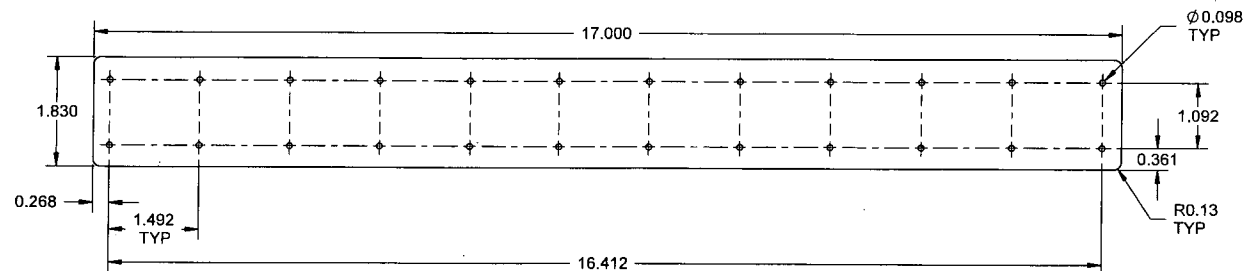
76577



D3234-1 DOUBLER



D3234-5 SPACER



D3234-3 DOUBLER

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO. D3234	REV. PC3
MFG. APPR.	<i>BC</i>	SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	11.09.29	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries